

Date: Tuesday, 11/13/2007 1:26:45 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: CAP		
Job Number	35663			Part Number	: D2855		
Estimate Number	10519			Drawing Number	: D2855 REV. A		
P.O. Number	:			Project Number	: N/A		
This Issue	11/13/2007	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	PURCHASED PARTS	Due Date	12/20/2007	Qty:	40 Um: Each
Previous Run	34998						
Written By	<u>10/07/11/13</u>						
Checked & Approved By							
Comment	Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: <u>5037</u> <i>Col 07/11/14</i> <u>40</u>	
		Cast per Dwg D2855	
		Material Release Note Required	
2.0	D2855P	Cap	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) CAP	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached	<i>7/12/12 54 40x</i>
4.0	QC6	DIMENSIONAL CHECK	 <i>Col 07/12/13 440</i>
		Comment: DIMENSIONAL CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	 <i>FF 07-12-14 40</i>
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Drill as per Dwg D2855 using DT8235 2- Open holes to 19/64" 3- Deburr	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP  Comment: INSPECT WORK TO CURRENT STEP <i>S 07/12/17 x40</i>
7.0	POWDER COATING	POWDER COATING  Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 <i>M 10 S 914 m-1 07/12/17</i>
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  Comment: INSPECT POWDER COAT <i>07-12-12 40x</i>
9.0	ALS71032225	INSERT  Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s) INSERT Pick: Qty Part Number Description Batch 2 ALS7-1032-225 Insert <i>M 100489 X?</i> or AKS7-1032-225 or ALS4-1032-225 or AKS4-1032-225 <i>M8</i>
10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  Comment: SMALL & MEDIUM FAB RESOURCE 1 Install Inserts as per Dwg D2855 <i>M8 07-12-17 40x</i>
11.0	QC5	INSPECT WORK TO CURRENT STEP  Comment: INSPECT WORK TO CURRENT STEP <i>M 07/12/17 x40</i>
12.0	PACKAGING 1	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FP-22 <i>M8 07-12-12 x40</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CAP

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Part Number: D2855

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2007/12/18

jl

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

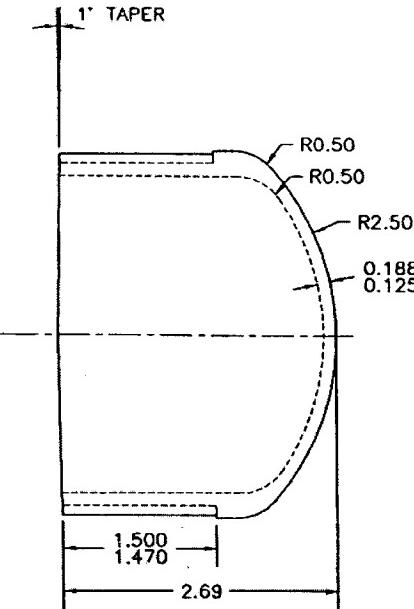
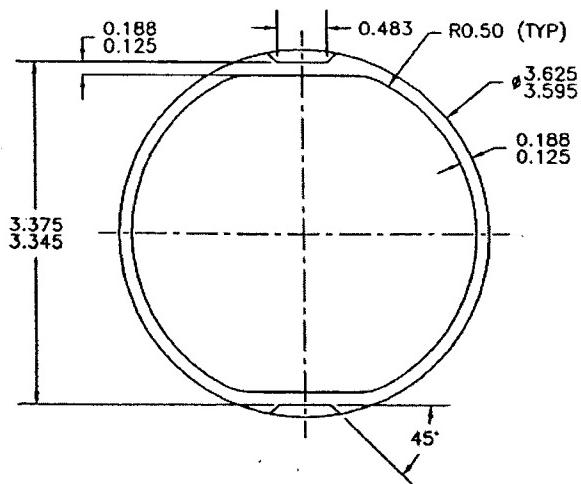
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

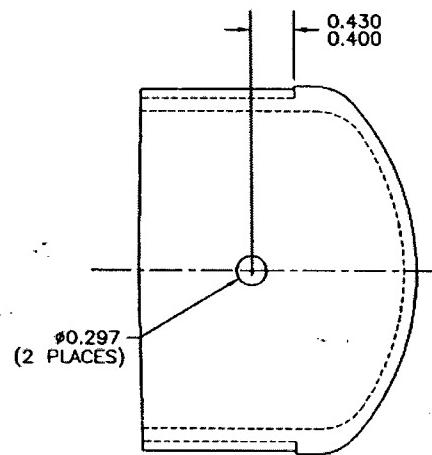
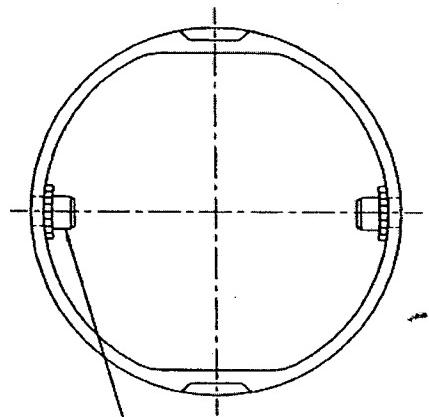
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2855 CASTING DETAIL



D2855 FINISHING DETAIL



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP (AFTER POWDER COAT)
(2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F) *KE 99.04.12*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *356063*

RELEASED
98.12.14 DS

DART

© A COPY IS
MADE

DESIGN <i>JH</i>	DRAWN BY <i>JH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
CHECKED <i>GP</i>	APPROVED <i>KE</i>	DRAWING NO. D2855	SHEET 1 OF 1
DATE 98.12.12		TITLE CAP	SCALE NTS
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)	

Aluminum Foundry Ltd

714-716 Calais
Dorval, Québec H9P 2P3
Tel: (514) 631-1331
Fax: (514) 631-8448
email: info@foundryafpw.com

Packing Slip

Packing Slip No.: 32337
Shipped Date: Dec 10, 2007

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKSLEY, ONTARIO K6A 1K7	DART AEROSPACE 1270 ABERDEEN STREET HAWKSLEY, ONTARIO K6A 1K7
Tel. (613) 632-3336 Fax (613) 632-4443	
Order No.: 5037	
Shipped By: PUROLATOR	
Tracking No.:	

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A <i>MJW</i> <i>SL</i>	40
Received by:			
Date:			
Comment:			

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

714-716 CALAIS, DORVAL, QC H9P-2P3
 TEL : (514) 631-1331 FAX: (514) 631-8448

Expédié à Shipped	DART AEROSPACE	A.F. & P.W.Série no./Serial no.
		Packing
	1270 Aberdeen Street	Date: <u>013/12/2007</u> Slip No. <u>32337</u>
	Hawksbury, ON, K6A 1K7	Votre No. Commande <u>5037, 5113</u> Your order No.

Ceci est pour certifié que le materiel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats di détaillante sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
70	D 2855 CAP	Z098046	A356.2	Ingot#850156
30	D 2965 CAP	Z200080	A356.2	Ingot#850156

Analysé
Analysis (as In Ingot)

(Si)	7.00%	(Al)	balance
(Fe)	0.08%		
(Cu)	0.00%		
(Mn)	0.00%		
(Mg)	0.40%		
(Zn)	<0.01%		
(Ti)	0.18%		

Donne Yield :	Résistance à la tension : Tensile Strength :	Allongement par pouce carré : P.S.I. Elongation : %
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Pour et au nom de
For and on behalf of:

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

Dept/Dep :
Par/Per : 